

**HEADING METHOD FOR OBTAINING 2 RING BODIES**

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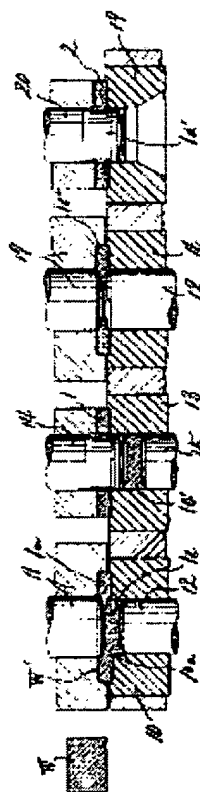
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**Abstract of JP57175045**

**PURPOSE:** To suppress generation of scraps to the minimum, and to efficiently manufacture 2 ring bodies with high accuracy from one material, by heading a material obtained by cutting a round bar material, by repeating to punch and die 2 times. **CONSTITUTION:** A material W obtained by cutting a metallic round bar material is thrust just in front of a die 10 provided with a knockout pin 12, is punched by a punch 11, and a disk body 1a is formed, and simultaneously, a projecting round part 1b concentrically formed in one body is formed, and a heading material W' is obtained.

Subsequently, the material W' is thrust just in front of a die 13, the projecting round part 1b is punched by a piercing tool 14, a cylindrical body 1b' is obtained, and from the disk body 1a, the first ring body 1 is obtained.

Subsequently, the cylindrical body 1b' is worked by a die 16 and a punch 17, a disk body 1b'' is formed, and after that, the second ring body 2 is obtained by punching a center hollowed part 1d' of the disk body 1b'' by a die 19 and a piercing tool 20.



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